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order 11464

D3713-042
Job Sheet 190309



Part No: D3713-042

Job Qty: 1 pcs

Part Name: Lid Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/7/19

Job Tracking No:

Due Date: 3/13/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D3715 REV A, D3713 REV B IPP Rev:A new issue 08-01-30 DD verified by:EC IPP Rev:B change to revB ecn 1145 08-03-19 DD verified by:EC IPP Rev:C add label DD 10.03.23 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	3/13/19		0.00	8.33	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		DAS 24
							Large Fab - 6		9-89
							Large Fab - 7		
							Large Fab - 8		MAR 18 2019
							Large Fab - 9		
110	Large Fab - Basket - 2 - B4B	1 pcs	3/13/19		0.00	8.33	Large Fab - 1 - B4B		
							Large Fab - 10 - B4B		MAR 18 2019
							Large Fab - 2 - B4B		
							Large Fab - 3 - B4B		
							Large Fab - 4 - B4B		DAS 24
							Large Fab - 5 - B4B		9-89
							Large Fab - 6 - B4B		
							Large Fab - 7 - B4B		
							Large Fab - 8 - B4B		
							Large Fab - 9 - B4B		
120	QC 5	1 pcs	3/13/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		DAS 43
							QC 5 - 43		9-89

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					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 9 - 10	
130 QC 9	1 pcs	3/13/19	0.00 0.00	QC 9 - 18		
				QC 9 - 24	DAS	
				QC 9 - 43	43	
				QC 9 - 50	9-89	
				QC 9 - 9		
140 Powdercoat - 4 Black Sand - B4B	1 pcs	3/13/19	0.00 0.26	Powdercoat - 1 - B4B		
				Powdercoat - 2 - B4B		
				Powdercoat - 3 - B4B	BL 19-03-18	
				Powdercoat - 4 - B4B		
150 QC 3	1 pcs	3/13/19	0.00 0.00	QC 3 - 10		
				QC 3 - 13		
				QC 3 - 15	ML 19-3-18	
				QC 3 - 17		
				QC 3 - 18		
				QC 3 - 2		
				QC 3 - 26		
				QC 3 - 28		
				QC 3 - 3		
				QC 3 - 30		
				QC 3 - 34		
				QC 3 - 36		
				QC 3 - 41		
				QC 3 - 51		
				QC 3 - 58		
				QC 3 - 59		
				QC 3 - 6		
				QC 3 - 68		
				QC 3 - 9		
160 Handfinish - 3-1- WingWalk-B4B	1 pcs	3/13/19	0.00 1.79	Handfinish - 3 - 1 - B4B	ML 19-3-18	
				Handfinish - 3 - 2 - B4B		
				Handfinish - 3 - 3 - B4B		
				Handfinish - 3 - 4 - B4B		
				Handfinish - 3 - 5 - B4B		
165 Spray Paint - 2 - B4B	1 pcs	3/13/19	0.00 0.00	Spray Paint - 1 - B4B	R.D. 19-3-19	
				Spray Paint - 2 - B4B		
				Spray Paint - 3 - B4B		
				Spray Paint - 4 - B4B		
170 QC 3	1 pcs	3/13/19	0.00 0.00	QC 3 - 10		
				QC 3 - 13		
				QC 3 - 15		
				QC 3 - 17		
				QC 3 - 18		
				QC 3 - 2		
				QC 3 - 26		
				QC 3 - 28		
				QC 3 - 3		
				QC 3 - 30		
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						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	DAS 528
						QC 3 - 6	
						QC 3 - 68	
						QC 3 - 9	
						Packaging 3 - 1 - B4B	
180 Packaging 3-1 - Stock - B4B	1 pcs	3/13/19	0.00	0.00		Packaging 3 - 2 - B4B	BFB 19-03-20
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Packaging 3 - 28 - B4B	
						Packaging 3 - 29 - B4B	
						Packaging 3 - 30 - B4B	
						Packaging 3 - 31 - B4B	
						Packaging 3 - 32 -	

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				B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
190 QC 21 - SA	1	3/13/19	0.00 0.00	QC 21 - SA - 21	
	pcs			QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - (Fabricate per Drwg) 1- Cut and Drill holes as per dwg D3713

Descriptions: 110 - (Weld per dwg A/R S.S. rod Batch: 138840) 1- WELD AS PER DWG

120 - QC5- Inspect part completeness to step on W/O)

130 - QC9- Inspect visual per QSI004- Fusion Welds)

140 - (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3) START TIME: 1:40 OVEN TEMPERATURE: 320°FINISH TIME: 2:10 M 138840

150 - (QC3- Inspect Part Finish)

160 - (Wing Walk as per dwg QSI005 4.4 Batch _____) 1-Apply Wing Walk on mesh as per Dwg D3713 and QSI 005 4.4 2

165 - (Spray Paint / NDT Room) APPLY ARMOR SHIELD OVER LABEL ONLY Enton clear 5138875

170 - (QC3- Inspect Part Finish)

180 - (Identify as per dwg & Stock Location: _____)

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2327-1 ✓	Spacer Bushing	2 pcs (2 ea)	100-Large Fab - Basket - 1	<u>5104170</u>
D2329	Label Plate	1 pcs (1 ea)	100-Large Fab - Basket - 1	<u>5159213</u>
D2581 ✓	Mounting Bracket	2 pcs (2 ea)	100-Large Fab - Basket - 1	<u>5146653</u>
D3749-1	Hinge Half	3 pcs (3 ea)	100-Large Fab - Basket - 1	<u>5155732</u>
M304TS0.750W.065	304 Sq Tube .75X.75X.065W	31.0220 ft (31.022 ea)	100-Large Fab - Basket - 1	<u>5155739</u>
M304EX0.75-16F	Expanded Metal Flat SS	17 sf (17 ea)	110-Large Fab - Basket - 2 - B4B	<u>5147379</u>
D2258-300	Placard	1 pcs (1 ea)	160-Handfinish - 3-1- WingWalk-B4B	<u>5152262</u>
				<u>608678</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2327-1	2	27	0
	D2329	1	0	0
	D2581	2	71	0
	D3749-1	3	3	0
	M304TS0.750W.065	31	331	0
110-Large Fab - Basket - 2 - B4B	M304EX0.75-16F	17	1,934	0
160-Handfinish - 3-1- WingWalk-B4B	D2258-300	1	5	0

Part Specifications

Specifications could not be found.

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78
00 86

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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Container No: S162810



Part: D3713-042

Job No: 190309

Serial No/Batch: S162810

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/14/19